120

Identify as per dwg & Stock Location:

0.00

120 Packaging

Memo

0.00

Packaging

								•		DQA:	Date:	•
NCR:	res /	No			WORK ORDER NON-C	COI	VFORN	/ANCE / UPD	ATE	0.4.611-	D-4-	
					-					QA Closed:	Date	
					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Order:				Rework	Skid-tube Crosstube			1	Water Jet	Engineering		
Part N	do.				Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raiti	V O				Use-as-is	1		noforming	Finishing	4	e/Packaging	Other
NCR I	No.				Work Order Update	1		Large Fab	Composite	1	Supplier	
						_						
Root				Descr	iption of work order update	1	Initial Action			Sign & ,	_	
Cause	Da	te Ste	p Qty		or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data						-		I				
Equip/Tooling		}						I		ļ		
Operator												
Material												
Setup												
Other												
Process	Ш											
Supplier												
Training	Ш		1								ļ	
Unapproved	<u> </u>			<u> </u>			TCATE	CORY			1	
					General	AUI	LT CATE	JURT				
Landi	ng Gear				Bend	Г	Grain			Ovalized		Pressure/Forced
Bending Centre Not Concentric to O/S			BOM/Route	\vdash	Hardwa	uro.	<u></u>	Over/Under	tolerance	Temperature/Cure		
			Broken/Damaged	-	-i	ion Incomplete	-	Part Incorre	├ ~~	Weld		
	Crac		~ d	-	Burrs	\vdash	-		Inclear —	Part Lost/M	⊢	Wrong Stock Pulled
٠	─ ─	ned/Crimp	ea.	-	Contamination	-	Instructions Incomplete/Unclear Maintenance			Part Moved		
÷	Cuff	Treat		-	Countersink	\vdash	Mislabe			Positioned \	Wrong	
:	⊢		in Tubo	-	Cut Too Short	-	Misread			Power Loss,	F	Other
	Inspection Strip in Tube Cut Too Short					L	1141131 Cac	•	L	٦٠٠٥٠ تا		1

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish

Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

99851

Page 2

April-12-13 8:15:14 AM

Item ID:

D3161-9

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name:

Required Date: 4/12/13

Hinge 17.0"

4/12/13

Start Qty: 4.00 **Req'd Qty:** 4.00 *4*

Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Start

Sequence ID/ Work Center ID Operation Description

Set Up/ **Run Hours** Tool ID

Tool # Plan

Date:

Accept Qty Code

Reject Qty

Run

Reject Number Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC.

Memo

0.00

Quality Control

NCR: \	⁄es	/ No				WORK ORDER NON-	COI	NFORI	AANCE / UPDAT	Έ	QA Closed:	Date	
											6.5		
Work Order:						DISPOSITION			А	AGAINST DE	PARTMENT/	PROCESS	
	_					Rework	7		Skid-tube Cr	rosstube		Water Jet	Engineering
Part N	No.					Scrap	1	r	Machining Sr	mall Fab	Prod	d. Eng. Coor.	Quality
	_					Use-as-is		Therm	noforming F	Finishing	Rec/Stor	e/Packaging	Other
NCR 1	No					Work Order Update]		Large Fab Cor	mposite	Supplier		
Doot					Descri	ption of work order update	Т	Initial	Action		Sign &	·	
Root Cause		Date	Step	Qty		or Non-conformance		ief Eng	Description	n	Date	Verification	QC Inspector
Doc/Data	\vdash	Date	step	Qty		or Non comormance	1	11.6					
Equip/Tooling	Н												
Operator	H												
Material	\forall												
Setup	Н						İ						
Other								į				i	
Process													
Supplier	П												
Training	П												
Unapproved	П												
						F	AUI	T CATE	GORY				
Landi	ng G	ear				General		٦		_	7	_	-
		Bending		Bend		Grain		<u> </u>	Ovalized	-	Pressure/Forced		
	Centre Not Concentric to O/S			BOM/Route	<u> </u>	Hardwa			Over/Under	-	Temperature/Cure		
Cracks		Broken/Damaged	-	- 1 `	on Incomplete	-	Part Incorred	<u> </u>	Weld				
Crushed/Crimped.			Burrs	_	-	ions Incomplete/Uncle	ear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	₽	Cuffs			<u> </u>	Contamination	\perp	Mainte		<u> </u>	Part Moved		
		Heat Trea			<u> </u>	Countersink	<u> </u>	Mislabe		-	Positioned V		7045
	\vdash	nspection		Tube		Cut Too Short	<u> </u>	Misread	i	L.	Power Loss/	Surge	Other
	-	Ripples in			<u> </u>	Drill Holes	<u> </u>	Offset					
Torque Waves in Extrusion				Drawing	Out of Calibration								

Out of Sequence

Outside Dimensions

DQA: _____ Date: ____

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Picklist Print

April-12-13 8:15:18 AM

Work Order ID: 99851

D3161-9

Parent Item Name: Hinge 17.0"

99851

D3161-9

Start Date: 4/12/13

Required Date: 4/12/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

Parent Item:

A04.08.24New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200	-	Purchased	No			100	f	14.7895	1.65	6.6	01	· ·-	
MS20257	<mark>7-3-72</mark> 00)							**	يخ	150	3/0	6/03

Piano Hinge

Loc Qty Loc Code Location ST209a 14.7894732 123960 14.7894732

17125445 6.6

Page 1

											DQA:	Date:		
NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFORN	MANCE / UPDATE		OA Classide	Doto:		
											QA Closed:	Date:	72.7.	
				DISPOSITION			AG	AINST DE	PARTMENT	PROCESS				
Work Orde	er: –					Rework	7		Skid-tube Cros	stube		Water Jet	Engineering	
Part N	VΩ					Scrap	1 1			all Fab	Pro	d. Eng. Coor.	Quality	
1 4761						Use-as-is	1		~ }	ishing	Rec/Stor	e/Packaging	Other	
NCR I	۷o					Work Order Update]		Large Fab Com	posite		Supplier		
D = -4			1		Doccri	ption of work order update		Initial Action			Sign &			
Root		Date	Step	Qty		or Non-conformance	1	nief Eng	Description		Date	Verification	QC Inspector	
Cause Doc/Data	러	Date	step	Qty		of Non-comormance	1	iici Liigi	Description.					
	Н													
Equip/Tooling Operator	H]											
Material	Н													
Setup	Н													
Other	Н											i	İ	
Process	H													
Supplier	Н	•												
Training	П													
Unapproved	П		ļ											
					-		AUI	LT CATE	GORY					
Landi	ng G	ear				General	_	7		_	7	_		
Bending .				Bend		Grain		ļ	Ovalized	_	Pressure/Forced			
Centre Not Concentric to O/S Cracks			BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under	<u> </u>	Temperature/Cure				
			Broken/Damaged	<u> </u>	-1 `	on Incomplete	<u> </u>	Part Incorre	 	Weld				
	-	Crushed/	Crimped.			Burrs	<u> </u>	4	ions Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs	•			Contamination		Mainte		<u> </u>	Part Moved			
	Ш	Heat Trea	at			Countersink	_	Mislabe			Positioned \	_	-	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	'Surge	Other	
		Rinnlas ir	Rend		1	Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G





DESIGN	F	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED		APPROVIO	DRAWING NO.	REV. A
K	}	TI	D3161	SHEET OF
DATE	2.04	211	TITLE	SCALE
 U.	2.04	. 44	HINGE	NTS
 Α	02	.04.24	NEW ISSUE	
ALH	tito	14.02.27	ADDED D3161-5	
GZ /	Patter	04.06 36	100 03/61-7 6 07/1/105	

P/N	LENGTH 'L'	DESCRIPTION
D3161-1	13.5"	HINGE (REPLACES MS20257-3-13.5 ON D2183)
03161-3	15.0"	HINGE (REPLACES MS 20257-3-150 ON D2950-041)
To deal stay	9.93	HINGE
7	14,0"	HINGE
	17.65	HINGE



None:

(1 MAKE FROM MSZOZS7-3-7200 HINGE

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